

Work Order ID 164704

Friday, July 28, 2017 8:23:45 AM

164704

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Item ID: D3537-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearpad

Start Date: 8/25/2017 Start Qty: 50.00

50

Cust Item ID:

Required Date: 9/7/2017 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals: Process Plan: Date: JUL 28 2017Tooling: Date: Run Start ***NR1***QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3537	E

110

0.00

110

FLOW WATER JET

Waterjet

Memo

1.85

FLOW CNC Waterjet

1-Cut D3537-1 as per Dwg D3537

Dwg Rev: EProg Rev: E

2-Deburr if necessary

5002/17/08/09

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.50

Quality Control

5002/17/08/09

DAS
 38
 9-89
 AUG 16 2017

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Item ID: D3537-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearpad
Start Date: 8/25/2017 Start Qty: 50.00 ***50*** Cust Item ID:
Required Date: 9/7/2017 Req'd Qty: 50.00 ***50*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* autoweld 1 Automated Welding 1	Weld per dwg & QSI004 4.5 Large Fab Memo ***SEE NOTE 8 FOR SURFACE BUILDUP*** 1- WELD AS PER DWG AND QSI004 4.5 FOR AUTOMATED WELDING USE 8259 HARDCOAT BATCH: <u>M137716</u>	0.00 5.00				<u>50</u>	<u>Q.L</u>	<u>17-08-22</u>	
170 *170* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.02 0.50				<u>50</u>			DAS 38 9-89 AUG 23 2017
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 1.00				<u>50</u>			DAS 38 9-89 AUG 23 2017

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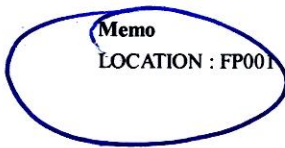
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Item ID: D3537-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearpad
Start Date: 8/25/2017 Start Qty: 50.00 ***50*** Cust Item ID:
Required Date: 9/7/2017 Req'd Qty: 50.00 ***50*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 *210* Packaging Packaging	Identify as per dwg & Stock Location: _____  Memo LOCATION : FP001	0.00 0.50				SO		DAS 6 9-89	AUG 25 2017
220 *220* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 5.00							17/9/5 JH

DAS
21
9-89

AUG 25 2017

Picklist Print

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Work Order ID: 164704

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Parent Item: D3537-1

D3537-1

Parent Item Name: Wearpad

Start Date: 8/25/2017

Required Date: 9/7/2017

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A New Issue 07-02-14 JLM
15.10.16 added automated welding DD verf:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	77.2920	0.106	5.578947			

M304S16GA

304/316 Sheet .063

**

06/17/08/09

Location

Loc Qty

Loc Code

MAT010

77.292

m136896

0.3

m137110

0.132

m137175

1.1

m137341

2.62

m137400

3.9

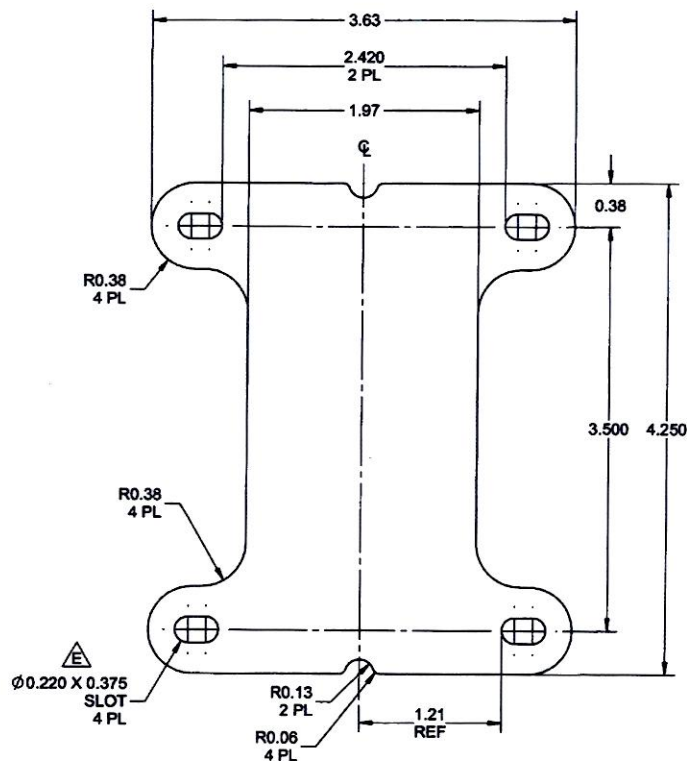
m137844

5.24

m138109

64

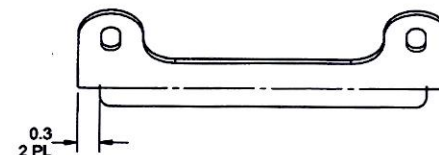
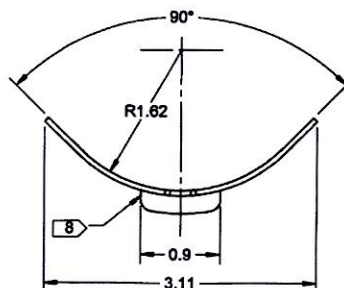
5.6



D3537-1F WEARPAD
(FLAT PATTERN)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 16 GAUGE 0.063 THICK
PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.42 lbs
- 8) BUILDUP HARD SURFACING 0.17 - 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR
BUILDUP HARD SURFACING 0.19 - 0.25 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)



D3537-1 WEARPAD

MAKE FROM D3537-1F

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 164704

JUL 28 2017

RELEASED
2015-12-07

ELN 15-651

E	-S DELETED PART IS OBSOLETE. RE-FORMAT. NOTE 8 RE-WRITTEN FOR ROBOTIC WELDING. SHEETS 1 & 2 SLOT DIMENSION UPDATED.	AJS	15.09.28
D	RE-FORMAT DRAWING, ADD -9/-11 WEARPADS	DB	14.10.16
C	WIDEN TAB TO 0.380, WEL. PATTERN	CB	07.04.13
B	ADD AMS5510 AND AMS 5524	CB	07.03.20
A	NEW ISSUE	CB	08.11.08
REV.	DESCRIPTION	BY	DATE
DESIGN	CB	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	AJS		
CHECKED	AP	DRAWING NO.	REV. E
MFG. APPR.	JLM	D3537	SHEET 1 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPAD	NTS
DATE	15.09.28	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIES OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

APPROVED